

5 I claim:

1. A recloseable bag having front and rear faces, comprising:

a bag, and

an elongate bendable shape-retaining spine bonded lengthwise to a face of the bag

10 and having a substantial elongate component substantially parallel to an edge of said bag.

2. A recloseable bag according to claim 1, wherein said shape-retaining material is formed with one section at an angle to its remaining section.

15 3. A recloseable bag according to claim 1, wherein said shape-retaining material is a T-shaped spine bonded to said bag using conventional heat sealing technology or adhesives.

20 4. A recloseable bag according to claim 1, wherein said shape-retaining material is an inverted L-shaped spine bonded to said bag using conventional heat sealing technology or adhesives.

5. A recloseable bag according to claim 2, wherein said bag is for storing food articles.

25 6. A recloseable bag according to claim 5, wherein said bag is folded and formed by a form, fill and seal (FFS) machine.

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7. A recloseable bag according to claim 6, wherein said bag is folded and formed by said FFS machine with a top seam, a bottom seam and a center rear seam.

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8. A recloseable bag according to claim 3, wherein said T-shaped spine is positioned with the horizontal axis of the T adjacent the top seam and the vertical axis of the T pointing towards the bottom seam.

9. A recloseable bag according to claim 1, wherein said seams are heat seams.

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10. The recloseable bag according to claim 3, wherein said T-shaped spine is formed of a bendable shape-retaining plastic polymer material.

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11. The recloseable bag according to claim 3, wherein said T-shaped spine is formed of resilient plastic having a bendable shape-retaining strand embedded centrally therein.

12. The recloseable bag according to claim 1, wherein said bag is further comprised of two of said spines bonded to the rear face of said bag, each of said two spines positioned parallel said center rear seam.

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13. A machine for manufacturing a recloseable bag with flat spines, comprising:
at least two feeder spools;

5 a tension roller;

 an articulating alignment spool;

 a press for bonding said spines to said bag material; and,

 servo-driven feed motors;

 wherein said servo-driven motors drive said feed spools; and,
10 wherein a first feeder spool feeds bag material, guided by said tension rollers and alignment
 spool, into said press and a second feeder spool feeds spine material into said press.

14. The machine according to claim 13, further comprising a heated press.

15 15. The machine according to claim 14, wherein said press is mounted to a hydraulic
 arm for proper stamping force.

16. The machine according to claim 15, wherein said press bonds said spines to said
bag material using a heat-weld.

20 17. The machine according to claim 13, wherein said press is equipped with an
 integral glue applicator for adhesive bonding of the spines to the bag material.

25 18. The machine according to claim 13, further comprising a press with an integral
 cutter; wherein said second feeder spool feeds a first unitary strip of spine material into said
 press and a first feeder spool feeds a second unitary strip of spine material into said press

5 perpendicular to said first unitary strip; and wherein said cutter cuts said first and second
unitary strips to form said T-shapes.

19. The machine according to claim 18, further comprising a second feeder spoil
integrated into an FFS machine for feeding said bag material with said bonded spines into
10 said FFS machine.

20. A method for producing a recloseable bag, comprising the steps of
feeding bag material into a press;
feeding bendable shape-retaining spine material into said press on said bag material;
15 and,
cutting and bonding said spine material to said bag material.